

ASAP

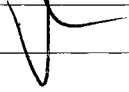
Work Order ID 123279

\*123279\*

Page 1

August-06-14 1:10:54 PM

Item ID: D4476-042 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Small Rib Assembly, RH  
 Start Date: 8/06/14 Start Qty: 2.00 \*2\* Cust Item ID:  
 Required Date: 8/15/14 Req'd Qty: 2.00 \*2\* Customer:  
 Reference:

Approvals: Process Plan:  Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4476	REV B								
100		0.00							
*100*									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	CUT BLANK 4.250" LONG								
110		0.00							
*110*									
Purchasing	Memo	0.00							
Purchasing	ISSUE P/O: <u>25345</u> TO ARCHUR PRECISION(GLOBUS) C OF C IS REQUIRED								
120	QC6- Inspect dimensions to drawing	0.00							
*120*									
QC	Memo	0.00							
Quality Control									

ms

14/6/11

14/7/10 (2)  
 14/8/23 (2)

2

DAS  
 38  
 9-89  
 14-9-24

# Work Order ID 123279

\*123279\*

Page 2

August-06-14 1:10:54 PM

Item ID: D4476-042 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
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Start Date: 8/06/14 Start Qty: 2.00 \*2\* Cust Item ID:  
Required Date: 8/15/14 Req'd Qty: 2.00 \*2\* Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00				2			
*130*	HandFinish	0.00							
Hand Finishing	Memo								
140	QC7-Inspect Chemical Conversion Coat	0.00				2			
*140*	QC	0.00							
Quality Control	Memo								
141	Spray Painting per QSI005 4.2	0.00				2			
*141*	SprayPaint	0.00							
Spray Painting	Memo								
	PRIME TEMPO GREY								
	128927								

Pho →  
KCC 14-4207

14/09/24.

DAS  
41  
9-89

14-9-25

# Work Order ID 123279

**\*123279\***

Page 3

August-06-14 1:10:54 PM

Item ID: D4476-042 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Small Rib Assembly, RH  
 Start Date: 8/06/14 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 8/15/14 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
142	QC14- Inspect Spray Paint	0.00							
<b>*142*</b>									
QC	Memo	0.00				②	1409.25		DAS 9 9-89
Quality Control									
150		0.00							
<b>*150*</b>									
Small Fab	Memo	0.00				2x			14/09/26
Small Fab	install nutplates as per dwg								
160	QC5- Inspect part completeness to step on W/O	0.00							
<b>*160*</b>									
QC	Memo	0.00				②			DAS 38 9-89 14-9-26
Quality Control									

DAS  
36  
9-89

# Work Order ID 123279

\*123279\*

Page 4

August-06-14 1:10:54 PM

Item ID: D4476-042 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Small Rib Assembly, RH  
 Start Date: 8/06/14 Start Qty: 2.00 \*2\* Cust Item ID:  
 Required Date: 8/15/14 Req'd Qty: 2.00 \*2\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location <i>MF</i>	0.00							DAS
*200*									26
Packaging	Memo	0.00				2x		SEP 2 5 2014	9-89
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
*210*									
QC	Memo	0.00							
Quality Control									

*MLJ 14-09-26*  
*MLJ 14-09-26*

# Picklist Print

August-06-14 1:10:54 PM

Page 1

Work Order ID: 123279

**\*123279\***

Parent Item: D4476-042

**\*D4476-042\***

Parent Item Name: Small Rib Assembly, RH

Start Date: 8/06/14

Required Date: 8/15/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 13-01-17 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20426AD3-4 <b>*MS20426AD3-4*</b> RIVET		Purchased	No				Each	5,584.000		4		14/09/26	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST315				5584					
					125578			3066					
					m127432			2518		4			
MS21059L08 <b>*MS21059L08*</b> Nut		Purchased	No				Each	735.0000		2		14/09/26	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST304				225					
					m129934			225					
				ST508				510					
					123185			1					
					125654			505		2			
					m124291			4					
M6061T6B0.750X03.00 0 <b>*M6061T6B0.750X03.000*</b> 6061-T6 Bar .750 x 3.00		Purchased	No				f	17.0000		1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT001				17					
					125272			1					
					m128437			16					
D4476-1P <b>*D4476-1P*</b> Small Rib (Lower Door)		Purchased	No				Each	0.0000		2			

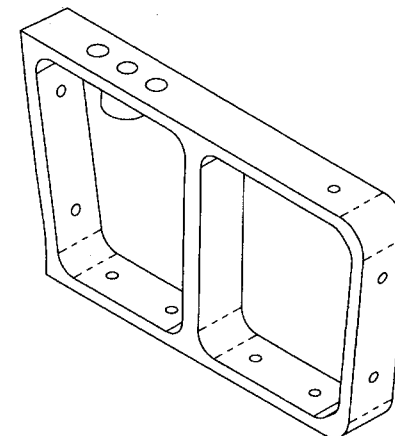
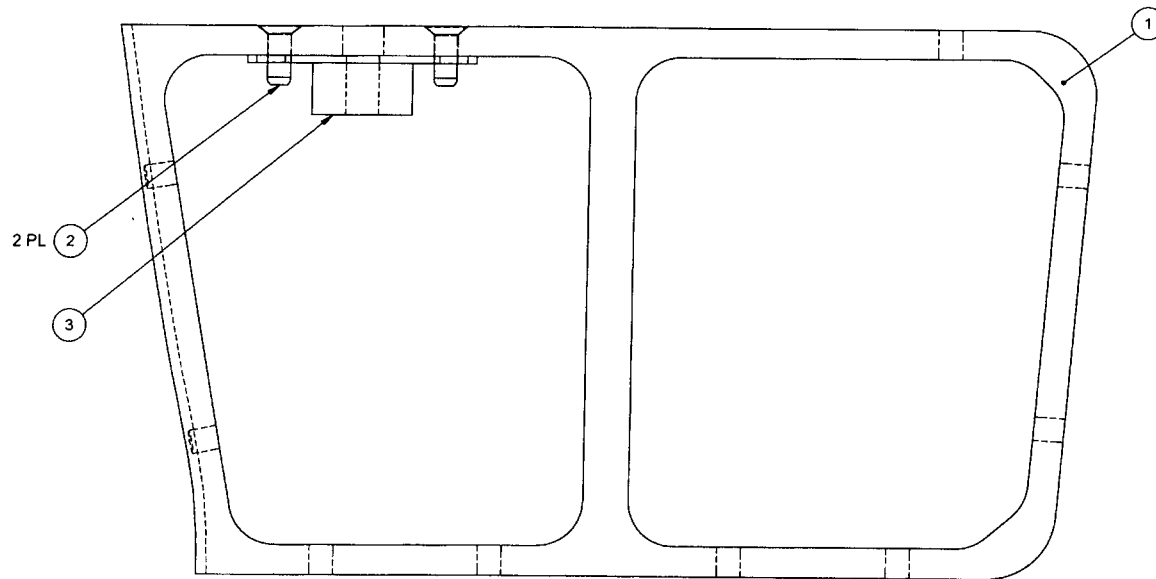
DAS  
10  
9-89

-2P

*Made supplied by Archival*

*C. W. H.*

ITEM	QTY	P/N	DESCRIPTION
	-042		
	X	D4476-042	SMALL RIB ASSY (RH)
1	1	D4476-2	SMALL RIB (RH)
2	2	MS20426AD3-4	RIVET, CSK
3	1	MS21059L08	NUTPLATE



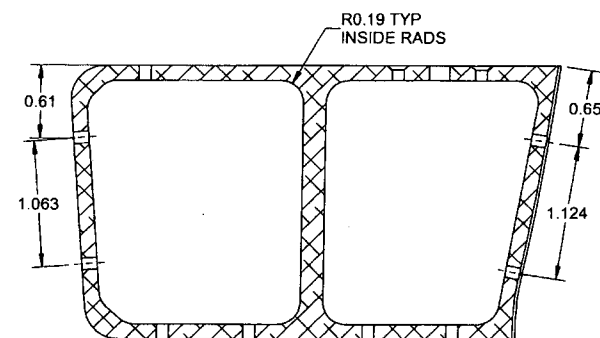
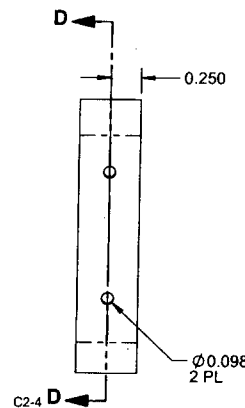
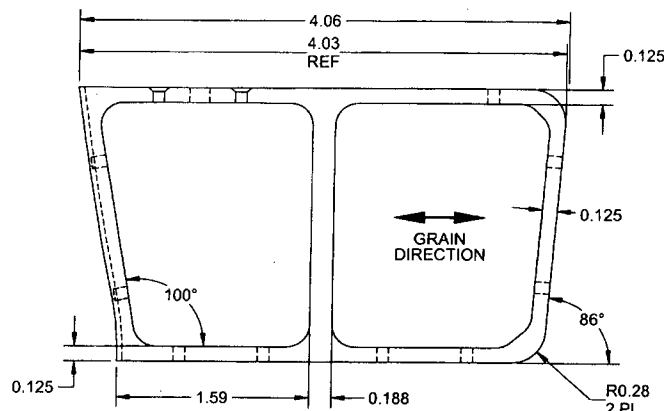
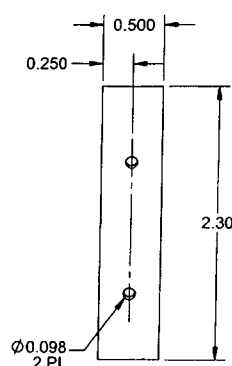
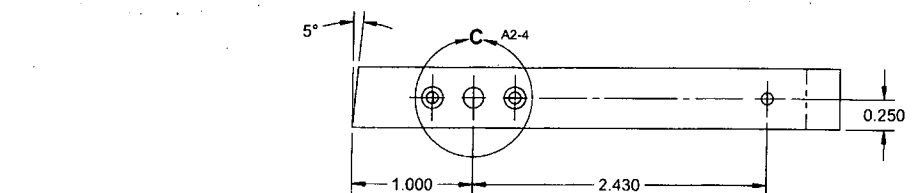
**D4476-042 SMALL RIB ASSY (RH)**

**NOTES:**

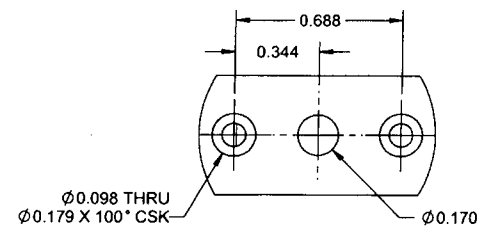
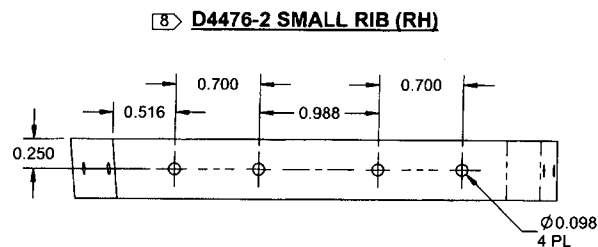
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AJS	DRAWING NO. <b>D4476</b>	REV. B
MFG. APPR.			SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>SMALL RIB ASSY</b>	NTS
DATE	12.09.10	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

**RELEASED**  
2012-09-18  
MP



SECTION D-D C4-4



DETAIL C D6-4

- NOTES:
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.09 lbs
  - 8) ALL NON-DIMENSIONED FEATURES DEFINED PER CAD FILE "D4476-2-REVB.STP"
  - 9) RAW MATERIAL SURFACE FINISH SUFFICIENT FOR THIS PART  
(NOT NECESSARY TO FACE MATERIAL)

RELEASED  
2012-09-18

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO. <b>D4476</b>	REV. B
MFG. APPR.			SHEET 4 OF 4
APPROVED		TITLE <b>SMALL RIB ASSY</b>	SCALE NTS
DE APPR.		COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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2228 Gladwin Cres.  
Ottawa, Ont.  
K1B 4S6

Telephone (613) 899-2405  
Fax (613) 226-1719

## Certificate of Compliance

To:  
Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury Ont.  
K6A 1K7

28Aug 2014

Po Number	Part Number	Quantities
25345	D4476-042P	2
	D4473-042P	2
	D4494-042P	2

It is hereby certified that all articles mentioned above are in conformance with the requirements, specification and drawings as listed on customer purchase order number, 24991 issued by Dart Aerospace Inc.

Greg Kumpula  
Quality Inspector  
Archer Precision Inc.  
2228 Gladwin Cress.  
Ottawa, Ontario  
K1B 4S6



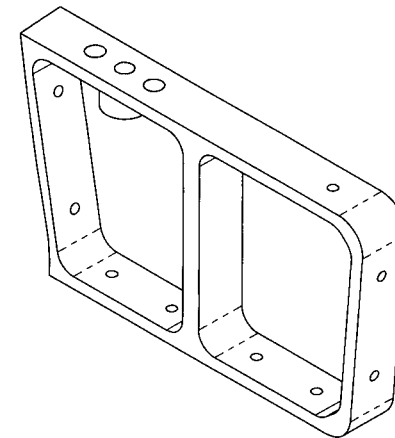
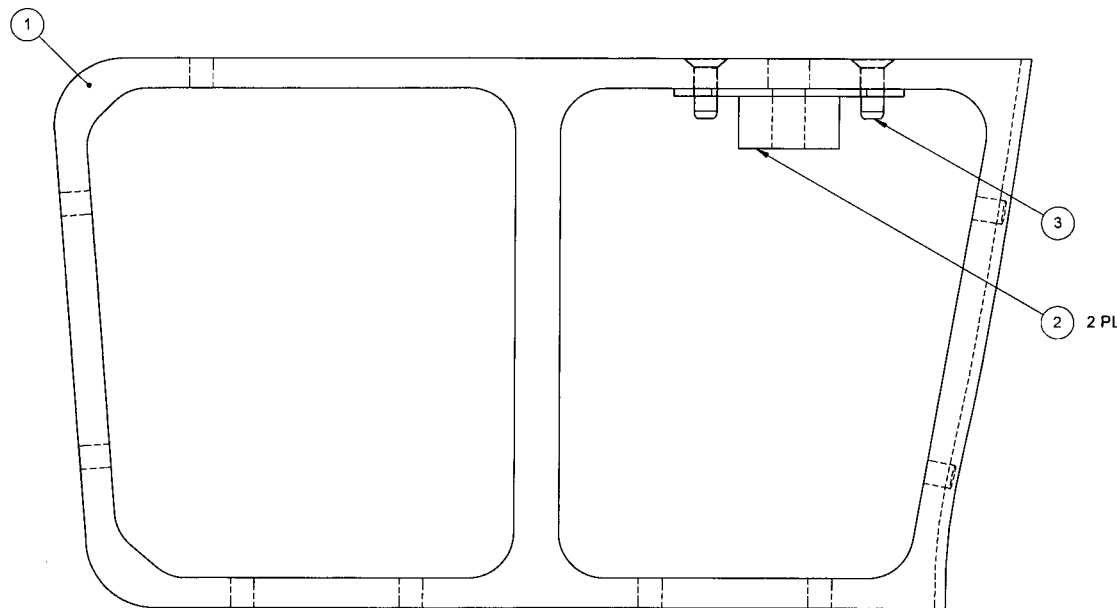
# Inspection Report

Customer Name		DART		DWG# 24476-1		Rev PB1		Part Name SMALL RIB		Date 2/9/14		Job #	
Page 1 of 2		Inspection Interval		Special Notes									
Item #	DWG. Dim	Tolerance	Operator	QA First Off		QA Final							
			First Off	A	R	A	R						
1	.500		.498										
2	2.30		2.298										
3	.096		.101										
4	4.03		4.023										
5	100°		100°										
6	.125		.126										
7	1.59		1.597										
8	.188		.189										
9	86°		✓										
10	.125		.126										
11	.700		.700										
12	.988		.987										
13	.516		.517										
14	.65		.647										
15	1.12		1.121										
16	.61		.608										
17	1.063		1.061										
18	2.430		2.431										
19	1.00		1.004										
20	5°		✓										
21	.098		.101										

[illegible]

LH

ITEM	QTY	P/N	DESCRIPTION
	X	D4476-041	SMALL RIB ASSY
1	1	D4476-1	SMALL RIB (LOWER DOOR)
2	1	MS21059L08	NUTPLATE
3	2	MS20426AD3-4	RIVET, CSK

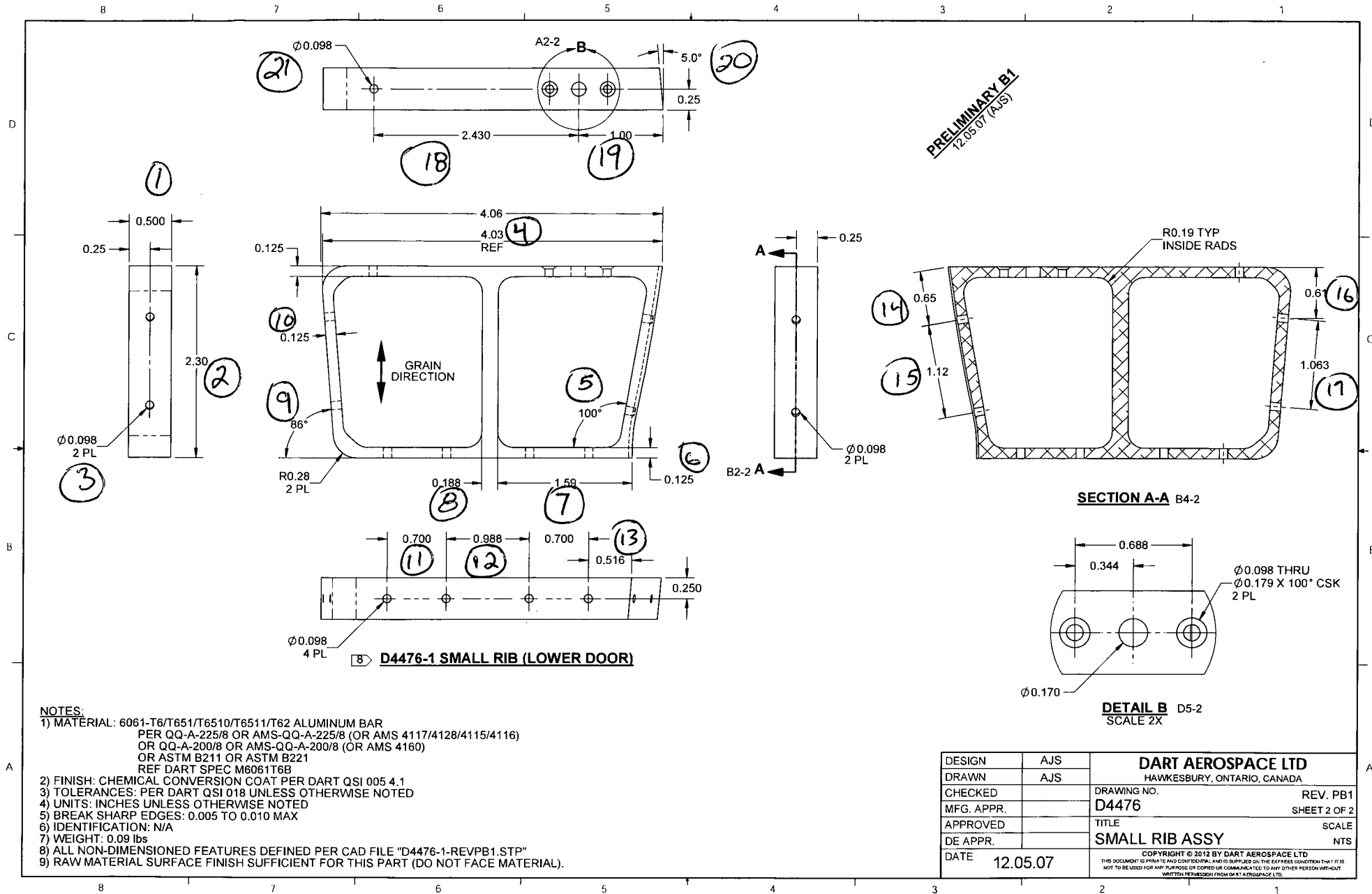


**D4476-041 SMALL RIB ASSY**

**PRELIMINARY B1**  
12.05.07 (AJS)

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.10 lbs

PB1	GENERAL REVISION SEE REV. A FOR DETAILS.		AJS	12.05.07
A	NEW ISSUE		AJS	11.11.22
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. PB1	
MFG. APPR.		<b>D4476</b>	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		<b>SMALL RIB ASSY</b>	NTS	
DATE	12.05.07		COPYRIGHT © 2012 BY DART AEROSPACE LTD. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	





Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **P025345**

Purchase Order Date 8/11/2014

PO Print Date 8/11/2014

Page Number 1 of 2

**Order From :**

VC-GLO001

ARCHER PRECISION INC.  
2228 GLADWIN CRESENT  
OTTAWA, ON K1B 4S6  
CA

**Ship To :** DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**Contact Name**

**Vendor Phone** 613 899 2405

**Ship To Contact**

**Ship To Phone**

**Ship Via:** FedEx Overnight collect

**Ship Acct:**

**Buyer**

**Customer POID**

**Customer Tax #** 10127-2607

**Terms** Net 30

**Currency** CAD

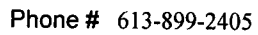
**FOB** EXW - (Ex Works)

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
Line Comments		Promise Date					
Delivery Comments							
1	d4476-042p	Small Rib Assembly,RH	8/11/2014 Yes 8/29/2014		2.00 Each	\$164.67	\$329.34
Manufacture as per Drawing D4476 rev.B Batch 123279							
						Line Total:	\$329.34
2	D4473-042P	Smal Rib Assy, RH	8/11/2014 Yes 8/29/2014		2.00 Each	\$164.67	\$329.34
Manufacture as per Drawing D4473 rev.B Batch#123280							
						Line Total:	\$329.34
3	D4494-042P	Upper Block Assy,RH	8/11/2014 Yes 8/29/2014		2.00 Each	\$222.33	\$444.66
Manufacture as per Drawing B4494 rev.D Batch# 123278							

**PO Instructions:** Fedex Acc#151793240

**Note:**

8/11/2014



Date	Invoice #
9/17/2014	1169

Ship To
Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. No.	Ship	Via	FOB	Project
25345	9/17/2014	delivered	Archer	

Qty	Item Code	Description
2	Sales	D4476-2
2	Sales	D4473-2
		HST (ON) on sales



2228 Gladwin Cres.  
Ottawa, Ont.  
K1B 4S6

Telephone (613) 899-2405  
Fax (613) 226-1719

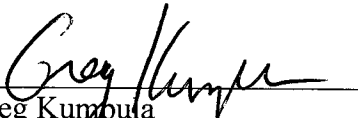
## Certificate of Compliance

To:  
Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury Ont.  
K6A 1K7

18 September 2013

Po Number	Part Number	Quantities
25345	D4476-2P	2
	D4473-2P	2

It is hereby certified that all articles mentioned above are in conformance with the requirements, specification and drawings as listed on customer purchase order number, 25345 issued by Dart Aerospace Inc.

  
Greg Kumpula  
Quality Inspector  
Archer Precision Inc.  
2228 Gladwin Cress.  
Ottawa, Ontario  
K1B 4S6

METAL SUPERMARKETS (OTTAWA)

ALUMINUM EXTRUDED

750" X 2.50" X 144,000"

PART NO.

PO Ref 507-3274

We certify that this is a true copy of the report  
furnished by the producer of the metal, or data  
resulting from tests made in approved labs.

## Certificate of Mill Test Results

REF: PEC-249520-001

13 Sep 13

Pg 1 of 1



## MILL TEST ASTM B221-12

TEL: (416)745-4444 FAX: (416)745-0925 1-800-668-7210  
411 CHRISLEA ROAD, WOODBRIDGE, ONTARIO, CANADA L4L 8N4  
<http://www.extrudex.com>

Cert Code:	1	0.65	DIE NUMBER	S	13590	DATE OF SHIPMENT	7/8/2013	EXTRUDEX ORDER NO.	158857 — 1	MANIFEST NO.	290628
CUSTOMER PO	PEC-249520		ALLOY	6061	TEMPER	T6511	SALESMAN	FORBES DODWELL	MADE IN CANADA		
SO DESCRIPTION	750"x2.5" FB		CUSTOMER PART NUMBER		PART DESCRIPTION				MILL TEST ASTM B221-12		

## Mechanical Properties

Lot	Alloy	Test Date	Ultimate Tensile Strength (KSI)	Yield Strength (KSI)	Percent Elongation	Hardness	Conductivity
A.11	6061	Jul/05/13	43.4	39.5	14.20	88.5,89.0,88.7	

## Chemical Composition

Cast Number	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti	Ga	V	B	Zr	Bi	Ph	Sn	Sr	Co	Al	Other
A.11 21058 6061	0.57	0.199	0.207	0.065	0.81	0.046	0.00	0.012	0.012	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	Remainder	0.00

We certify that the following extrusions have been quality inspected/tested and conforms to required dimensional and temper specifications.

David Natale  
Quality Control Manager

1 - CUSTOMER COPY

MILL TEST ASTM B221-12



8 7 6 5 4 3 2 1

D

C

B

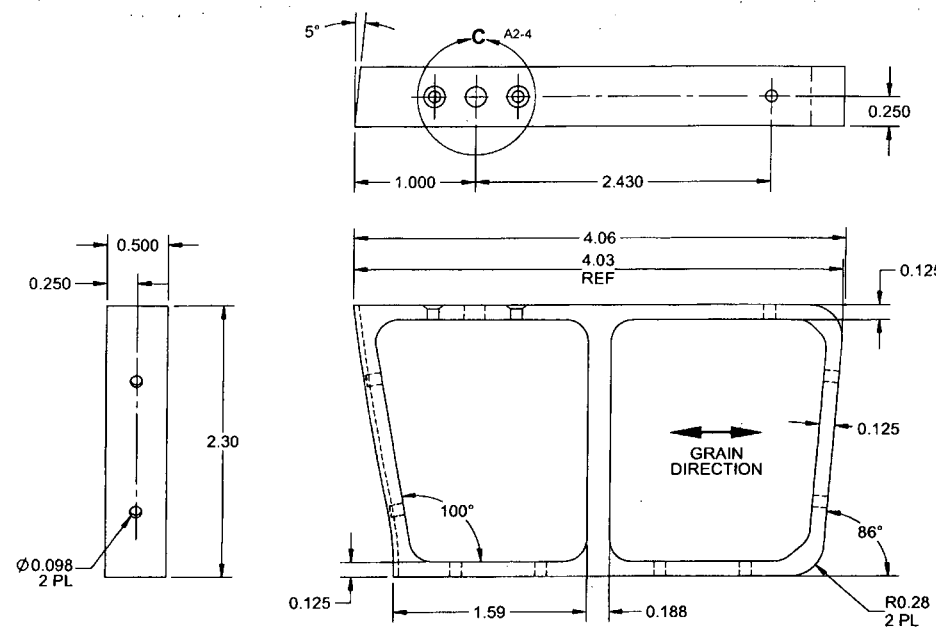
A

D

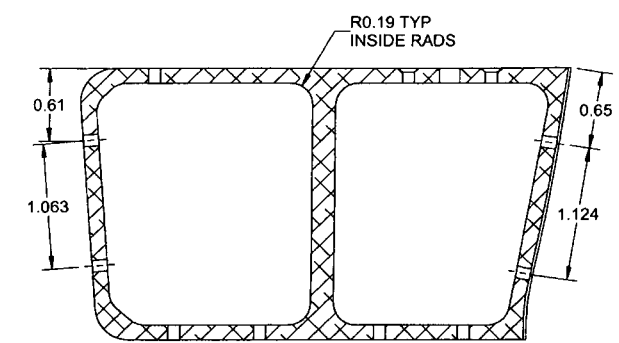
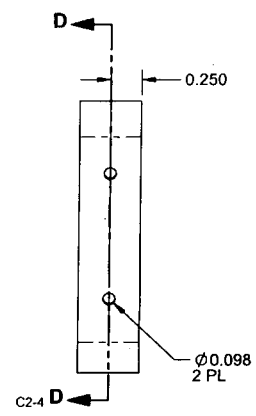
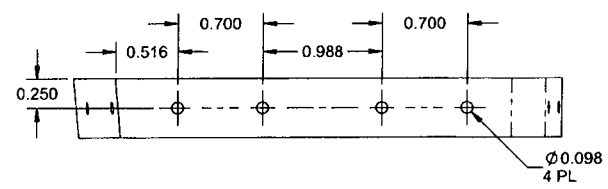
C

B

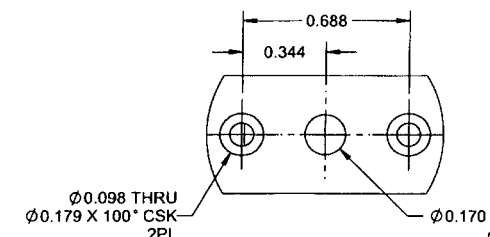
A



**[8] D4476-2 SMALL RIB (RH)**



**SECTION D-D C4-4**



**DETAIL C D6-4**

- NOTES:**
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.09 lbs
  - 8) ALL NON-DIMENSIONED FEATURES DEFINED PER CAD FILE "D4476-2-REVB.STP"
  - 9) RAW MATERIAL SURFACE FINISH SUFFICIENT FOR THIS PART  
(NOT NECESSARY TO FACE MATERIAL)

**RELEASED**  
2012-09-18

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.		D4476	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SMALL RIB ASSY	NTS
DATE	12.09.10	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1



# Archer Precision

Short date 9/18/14

ZEISS

Plan Name D4476-2

Part No.: \* u\_prtnu \*

Customer: \* u\_cus \*

Rev.:

u\_jobnum \* u\_jobnum \*

u\_qtynu \* u\_qtynu \*


Customer PO.: \* u\_Cuspo \*

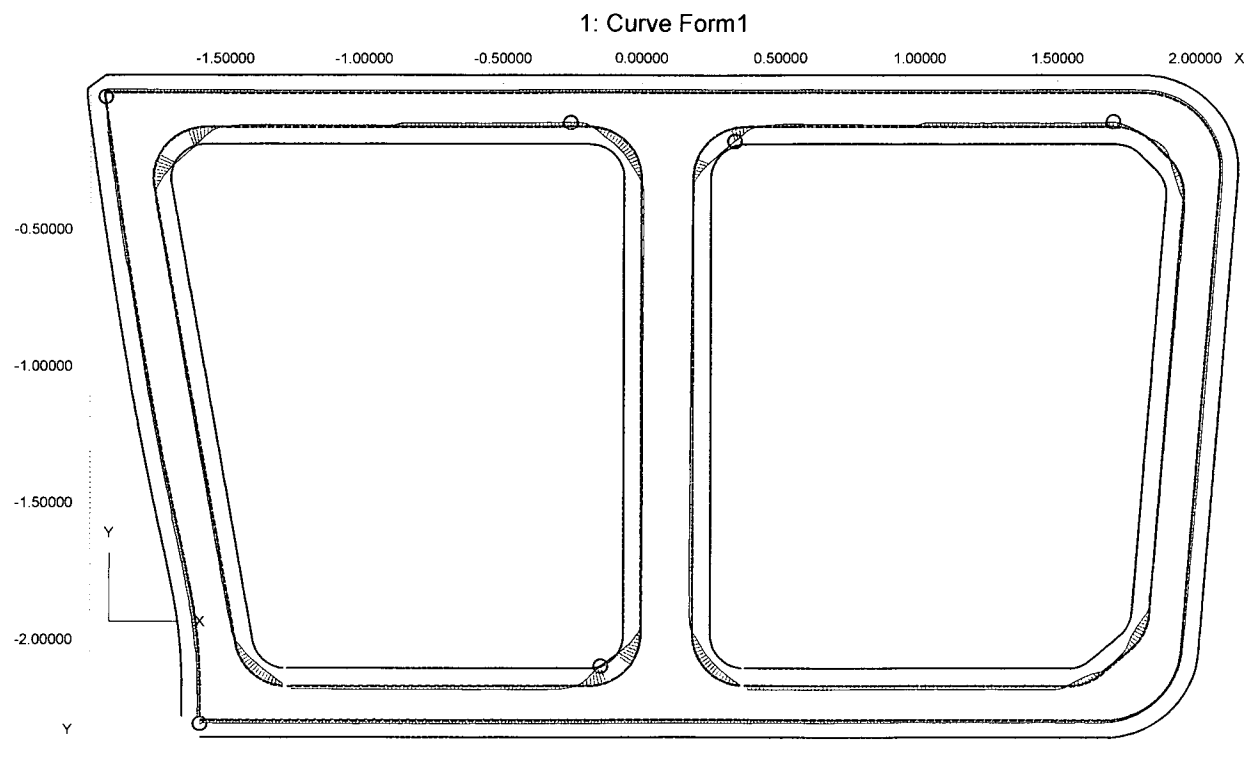
BSN:

u\_mtl \* u\_mtl \*

Incr. Smpl No.: 1

Name	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<-- -->
■ OA Height	Z	-0.49945	-0.50000	0.00500	-0.00500	0.00055	-
■ Curve Form1	CurvForm	0.00253	0.00000	0.01000		0.00253	--
Curve Form2	CurvForm	0.01030	0.00000	0.01000		0.01030	----
■ Curve Form3	CurvForm	0.01265	0.00000	0.01000		0.01265	0.00022

 <b>Calypso</b> 5.6.08		<b>Carl Zeiss</b>		<b>Date</b> September 18, 2...	
<b>Part Number</b> 1		<b>CMM Type</b> CONT_G2		<b>Drawing No.</b>	
<b>Meas. Plan Name</b> D4476-2		<b>Department:</b> <b>Operator</b> <b>Signature:</b>		<b>Master</b>	



No	Identifier	Sigma [in]	Form [in]	Number of Points	Lower Tol. [in]	Upper Tol. [in]	MinInd	Min Dev. [in]	MaxInd	Max Dev. [in]	Best Fit	X [in]	Y [in]	Z [in]		X	Y	Z
1	Curve Form1	0.00156	0.00253	999	0.00000	0.01000	807	-0.00045	1	0.00207	Translation	-0.00059	-0.00154	0.00000	Rotation	0.00000	0.00000	0.00051
2	Curve Form2	0.00201	0.01030	487	0.00000	0.01000	247	-0.00304	344	0.00727	Translation	-0.00117	-0.00406	0.00000	Rotation	0.00000	0.00000	0.02805
3	Curve Form3	0.00259	0.01265	482	0.00000	0.01000	236	-0.00243	82	0.01022	Translation	-0.00143	-0.00357	0.00000	Rotation	0.00000	0.00000	0.00481